

Date: Wednesday, 12/7/2005 8:25:38 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : JACK SADDLE
Job Number : 25132	
Estimate Number : 11177	
P.O. Number : 25132 N/A	Part Number : D2281
This Issue : 12/7/2005 S.O. No. : N/A	Drawing Number : D2281 REV G
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : SMALL /MED FAB	Drawing Revision : G
Previous Run : NIP	Material : NIP
Written By : <u>SEE COMMENT BELOW</u>	Due Date : 12/20/2005 Qty: 100 Um: Each
Checked & Approved By : <u>SEE COMMENT BELOW</u>	
Comment : Est Rev:A Removed from 9 Digit 05-12-02 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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Comment: PURCHASING 245
 Issue P/O: _____ Email or Ship Dxf file to vendor
 Laser cut as per Dwg D2281
 Material release note required.

UL 95-12-07 100

2.0	D2281F	Jack Saddle
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 100.0000 Each(s)
 Jack Saddle

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
 Receive & Inspect For Transit Damage
 Ensure material certification is attached

DL 05/12/23 101

4.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK

05-12-28 101

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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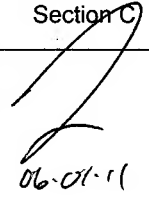

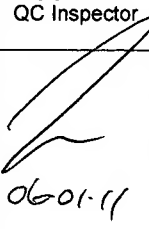
Comment: Deburr

FF 06-01-03 100

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06/01/11	6	1 part is scrap because it's dent croche crooked.		Scrap & destroy	SP 06/01/11	 06-01-11		 06-01-11

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: JACK SADDLE

Job Number: 25132

Part Number: D2281

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Form as per D2281 using D2281-T2

SB 06/01/11 100 PTO

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06-01-11

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

CL 06/01/11 101

9.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

54E 06/01/13 (101)

SD 06/01/18 (101)

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

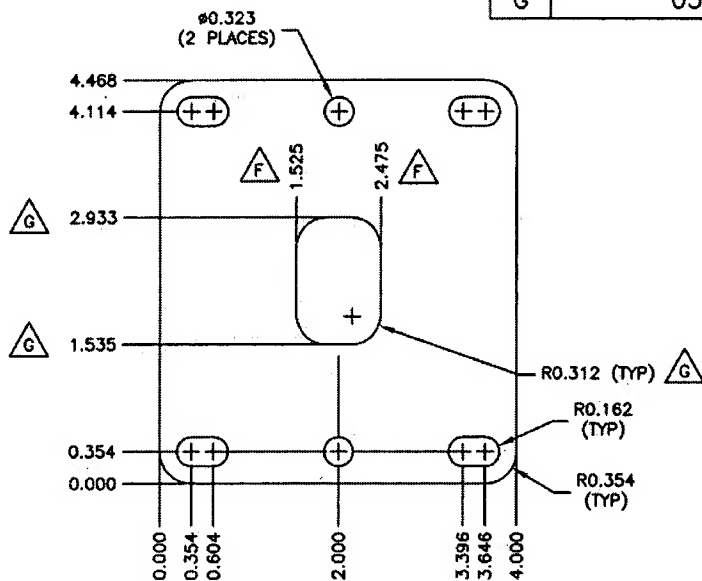
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

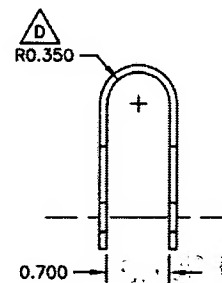
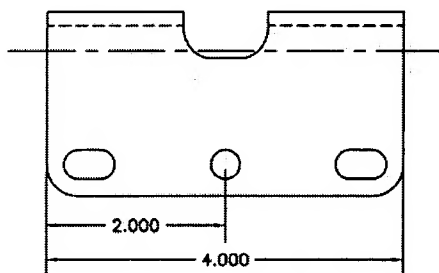


DESIGN BW	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2281	REV. G SHEET 1 OF 1
DATE 05.06.07		TITLE JACK SADDLE	SCALE 1:2
A	94.10.14	NEW ISSUE	
B	94.10.18	DIMENSION WAS 2.878	
C	94.11.04	ADD TOOLING NOTCH	
D	98.03.27	R0.350 WAS R0.280	
E	04.11.18	REMOVE TOOLING NOTCHES	
F	05.03.16	REDESIGN FLAT PATTERN	
G	05.06.07	REDESIGN FLAT PATTERN	

RELEASED
[Signature]
05/08/11



FLAT LAYOUT



TO BE CONF
TO BE CONF
TO BE CONF
TO BE CONF

D2281 JACK SADDLE

- 1) MATERIAL: 304/316 SS, 0.080 THICK (REF DART SPEC. M304S14GA)
- 2) FINISH: NONE
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

05132

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MATERIAL TEST/INSPECTION CERTIFICATE

YIEH MAU CORP.
YIEH MAU CORP.

INVOICE NO. :
COMMODITY :

P05M438R
PRIME COLD ROLLED STAINLESS STEEL SHEET

SPECIFICATION :

CUSTOMER :

AISI 304
INTEGRIS METALS LTD

149a 55 3042B
part # D2281-206
105-12-28
工廠:高雄路竹鄉廣安路345號
345, SHUN AN RD. LU CHU HSI
KAOHSIUNG TAIWAN R.O.C.
TEL:(07)672885 FAX:(07)67300
CERTIFICATE NO: P05M438R
DATE OF ISSUE:05/01/2005
PAGE:2/2

BUYER'S ITEM NO.	SIZE	NO.	Weight (N.W.)		Heat No.	ID NO.	Physical Properties Tensile Test GL-50 mm					Chemical Composition (%)							
			KGS	LBS			Y.S. (N/mm ²)	T.S. (N/mm ²)	E.L. (%)	HRB	HV	C x100	Si x100	Mn x100	P x1000	S x1000	Ni x100	Cr x100	N x100
AISI 304, NO.4 (SIC) FINISH, WITH 100 MIC. FILM ON MAIN SIDE, WITH BACK-PASS, SLITTED EDGE.																			
7427-7166	11GA/48"X 96"	1	1,469	3,217	YU137453	44S65351A-112	318	669	51	84	167	4.5	47	115	31	2	808	1832	3.5
7427-7166	11GA/48"X 96"	1	1,474	3,250	YU136039	45S66756B-111	298	644	51	85	171	5.4	48	121	31	11	809	1849	3
AISI 304, 2B FINISH, WITH PAPER INTERLEAVED, SLITTED EDGE.																			
7425-6961	22GA/48"X120"	1	1,430	3,153	YU233420	43S63676B-21	278	659	63	83	163	4.1	50	122	33	4	804	1813	3.3
7426-5059	16GA/48"X 96"	1	1,279	2,820	YU137477	44S65315RB-22	304	672	51	82	169	4.4	48	118	35	3	814	1814	3.4
7426-5497	16GA/60"X120"	1	1,410	3,109	YU233638	44S64690A-21	289	658	50	81	158	3.9	49	121	31	4	806	1824	2.9
7426-8053	14GA/48"X120"	1	1,456	3,210	YU230936	44S67866A-5	295	657	50	81	167	3.8	50	111	26	2	812	1808	3
7426-7949	14GA/48"X 96"	1	1,466	3,232	YU230936	44S67866A-1	295	657	50	81	167	3.8	50	111	26	2	812	1808	3
7426-7949	14GA/48"X 96"	1	1,468	3,232	YU230936	44S67866A-2	295	657	50	81	167	3.8	50	111	26	2	812	1808	3
7427-3699	12GA/48"X120"	1	1,447	3,190	YU137387	44S64897-11	314	664	50	86	173	5	50	124	32	4	808	1815	3.4
7427-3699	12GA/48"X120"	1	1,460	3,197	YU137387	44S64897-12	314	664	50	86	173	5	50	124	32	4	808	1815	3.4
7427-3699	12GA/48"X120"	1	1,451	3,199	YU137887	44S64897-13	314	664	50	86	173	5	50	124	32	4	808	1815	3.4
7427-3699	12GA/48"X120"	1	1,446	3,188	YU136911	44S64898-215	294	637	54	82	161	4.4	51	127	30	3	818	1807	2.7
7427-3641	12GA/48"X 96"	1	1,462	3,223	YU136911	44S64898-216	294	637	54	82	161	4.4	51	127	30	3	818	1807	2.7
7427-4127	12GA/60"X120"	1	1,428	3,144	YU137982	44S64898-214	294	637	54	82	161	4.4	51	127	30	3	818	1807	2.7
7427-4242	12GA/60"X144"	1	1,370	3,020	YU137982	45S00273-22	294	664	52	84	168	4	50	117	28	2	810	1817	2.4
7427-8445	11GA/48"X120"	1	1,398	3,082	YU233792	44S85308A-16	317	681	47	86	173	4.1	52	115	34	3	805	1807	2.8
7427-8445	11GA/48"X120"	1	1,137	2,507	YU233792	44S85308A-17	317	681	47	86	173	4.1	52	115	34	3	805	1807	2.8
AISI 304, NO.4 (SIC) FINISH, WITH 100 MIC. FILM ON MAIN SIDE, WITH BACK-PASS, SLITTED EDGE.																			
7426-6343	16GA/60"X96"	1	1,285	2,833	YU138717	44S65088B-11	299	653	52	81	156	4.2	48	111	30	4	814	1831	2.4
19			26,758	58,994															
NO MERCURY CONTAMINATION																			
Bend test: good for all Heat NO.																			
I HEREBY CERTIFY THAT THE MATERIAL DESCRIBED HEREIN HAS																			
BEEN MADE IN ACCORDANCE WITH THE RULES OF THE AISC CERTIFICATION																			

NO MERCURY CONTAMINATION
Bend test good for all Heat NO.
HEREBY CERTIFY THAT THE MATERIAL DESCRIBED HEREIN HAS
BEEN MADE IN ACCORDANCE WITH THE RULES OF THE MILL CERTIFICATE.

- PRIME MATERIAL. NO DINGS, NO DENTS, NO SCRATCHES
- P.O. NO. 447002 (VANCOUVER)
- SALES CONTRACT: P05M438
- DOCUMENTARY CREDIT NUMBER: ILCMSP002723

YIEH MAU CORP.

Manager of Quality Assurance Section